

# Work Order ID 57197

March 29, 2010 11:23:44 AM



Page 1

Item ID: D212-664-201TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 29/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 05/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: *10-3-29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw / Plan Rev. Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D212-664-241

Rev D

100



Mori Seiki

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114  
2-Turn first side as per Folio FA114  
3- File transition lines smooth.

*Q.M. 10 - 05 - 03*

110



QC

QC1- Inspect dimensions to dimension sheet

0.00

Memo

0.00

Quality Control

*Q.M. 10 - 05 - 03*

120



Mori Seiki

MORI SEIKI CNC LATHE LARGE

0.00

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA114  
2- File transition lines smooth.  
3-Remove sand and plugs  
4- scribe batch # and part # as per dwg

*Q.M. 10 - 05 - 03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57197**

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Page 2

Item ID: D212-664-201TRN

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Start Date: 29/03/2010 Start Qty: 1.00



Required Date: 05/04/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC1- Inspect dimensions to dimension sheet

0.00

QC

Memo

0.00

Quality Control

Qd 10 - 05 - 03 ①

140



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

IX MB 10-05-03

150



Crosstubes Chemical Conversion

0.00

HandFXtube

Memo

0.00

Hand Finishing Crosstubes

Chemical Conversion Coat as per within 24 hours of machining

IV MB 10-05-03

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop



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Start Date: 29/03/2010 Start Qty: 1.00



Required Date: 05/04/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				(01)	0		10/05/03
170 	Packaging	0.00							
Packaging Packaging	Memo Identify and stock in kanban rack Location: <i>* tube cell</i>	0.00				(10)	0	MB	10-05-03
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							10/05/04 <i>H</i>

BS 10-5-04  
(1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

March 29, 2010 11:23:48 AM

Page 1

Work Order ID: 57197

Parent Item: D212-664-201TRN

Parent Item Name: Crosstube Turning Detail

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
IPP Rev B 08.04.02 Removed polish EC verified DD

Start Date: 29/03/2010

Required Date: 05/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6006-129		Manufactured	No			120	Each	54.0000	1.0000			



Crosstube Material



Q.n 10-05-030

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
LG	54	
23970	2	
26550	15	
34690	11	
38338	26	

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 571a7
<b>Description:</b> Crosstube Assembly (205/212 High Aff)		<b>Part Number:</b> D212-664-241
<b>Inspection Dwg:</b> D212-664-241 Rev: 8D		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200	/			
	R0.063	+/-0.010	R0.063	/			
	2.990	+0.005/-0.000	2.990	/			
	5.237	+/-0.030	5.237	/			
	2.600	+0.005/-0.000	2.604	/			
	2.686	+0.005/-0.000	2.689	/			
	2.770	+0.005/-0.000	2.775	/			
	2.854	+0.005/-0.000	2.859	/			
	2.938	+0.005/-0.000	2.943	/			
	3.021	+0.005/-0.000	3.026	/			
	3.133	+0.005/-0.000	3.137	/			
	3.179	+0.005/-0.000	3.184	/			
SIDE B	0.200	+/-0.010	0.200	/			
	R0.063	+/-0.010	R0.063	/			
	2.990	+0.005/-0.000	2.990	/			
	5.237	+/-0.030	5.237	/			
	2.600	+0.005/-0.000	2.605	/			
	2.686	+0.005/-0.000	2.689	/			
	2.770	+0.005/-0.000	2.775	/			
	2.854	+0.005/-0.000	2.859	/			
	2.938	+0.005/-0.000	2.943	/			
	3.021	+0.005/-0.000	3.026	/			
	3.133	+0.005/-0.000	3.137	/			
	3.179	+0.005/-0.000	3.184	/			
	124.36	+/-0.020	124.360	/			

<b>Measured by:</b> C. M.	<b>Audited by:</b> MB	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-05-03	<b>Date:</b> 10-05-03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	

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**NOTE:** Date & initial all entries

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	4	4	MS21920-28	CLAMP (OR MS21920-30)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.362±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)  
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING  
IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE  
OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS  
AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE  
SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR  
DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND  
MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT  
HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57197

*BS 10-3-29*

**RELEASED**  
R 2009-10-29  
*WY*

D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C8-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RF</i>		
CHECKED	<i>Q</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>DS</i>	D212-664-241	SHEET 1 OF 4
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>H</i>	CROSSTUBE ASSY (205/212 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

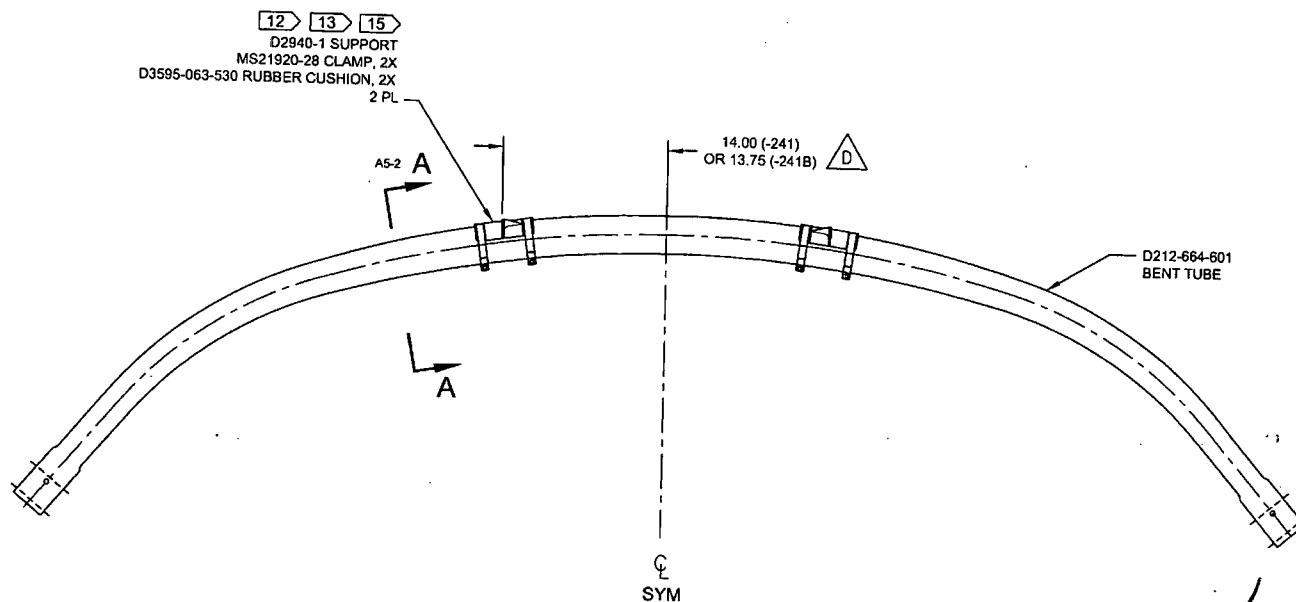
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

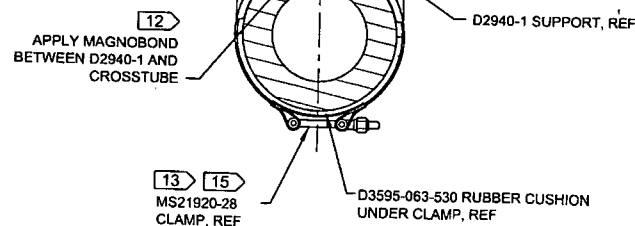
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D212-664-241/-241B  
ASSEMBLY DETAIL** D



**SECTION A-A** D6-2  
SCALE 4X

**RELEASED**  
2009-10-28  
WJ

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	9	DRAWING NO.	REV. D
MFG. APPR.	SS	D212-664-241	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
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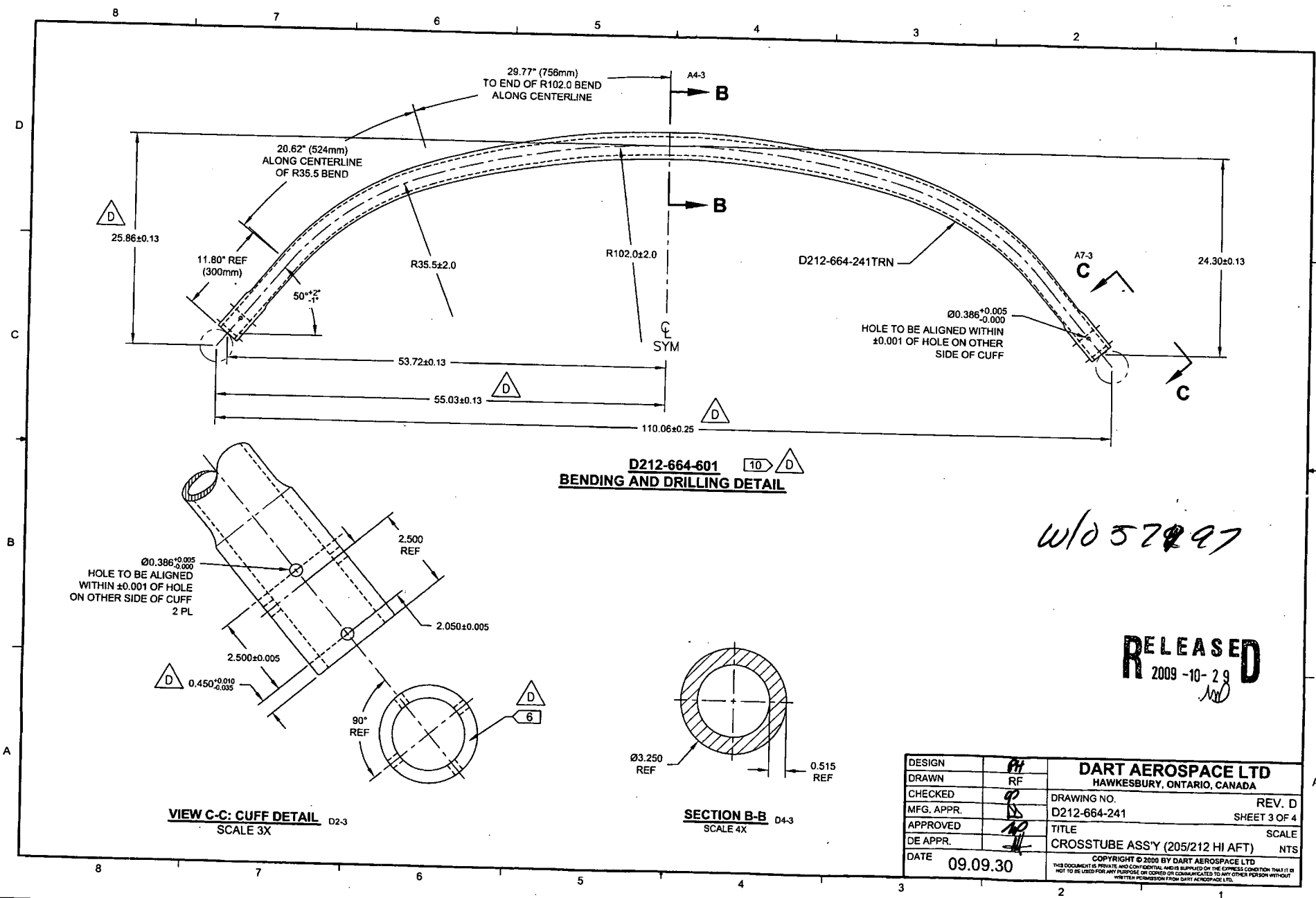
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RELEASED  
2009-10-29

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DRAWN	RF		
CHECKED	PS	DRAWING NO.	REV. D
MFG. APPR.	PS	D212-664-241	SHEET 3 OF 4
APPROVED	PS	TITLE	SCALE
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R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

R100.0 TRANSITION  
BETWEEN TAPERED  
SECTIONS

0.515 WALL  
STOCK, REF

SEE DETAIL D

0.000  
2.600<sup>+0.005</sup><sub>-0.000</sub>

11.795<sup>+0.030</sup>  
2.686<sup>+0.005</sup><sub>-0.000</sub>

16.950<sup>+0.030</sup>  
2.770<sup>+0.005</sup><sub>-0.000</sub>

22.105<sup>+0.030</sup>  
2.854<sup>+0.005</sup><sub>-0.000</sub>

27.260<sup>+0.030</sup>  
2.938<sup>+0.005</sup><sub>-0.000</sub>

32.415<sup>+0.030</sup>  
3.021<sup>+0.005</sup><sub>-0.000</sub>

39.264<sup>+0.030</sup>  
3.133<sup>+0.005</sup><sub>-0.000</sub>

42.114<sup>+0.030</sup>  
3.179<sup>+0.005</sup><sub>-0.000</sub>

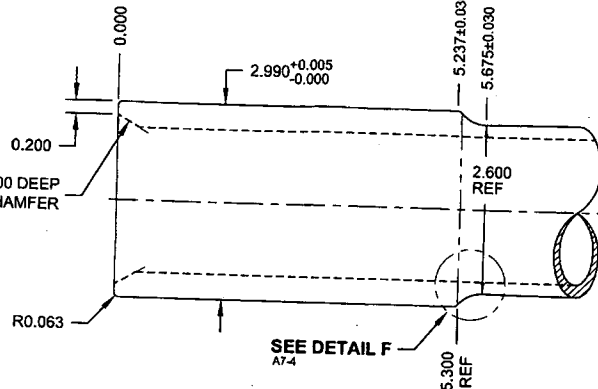
46.114<sup>+0.030</sup>  
3.250 STOCK, REF

62.181 REF  
C SYM

SEE DETAIL E

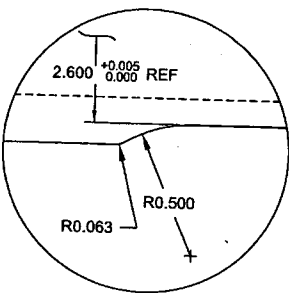
TAPER UNIFORMLY FROM  
3.179<sup>+0.005</sup><sub>-0.000</sub> THROUGH TO 3.276<sup>+0.005</sup><sub>-0.000</sub>  
RUNNING OFF PART

30° X 0.500 DEEP  
CHAMFER

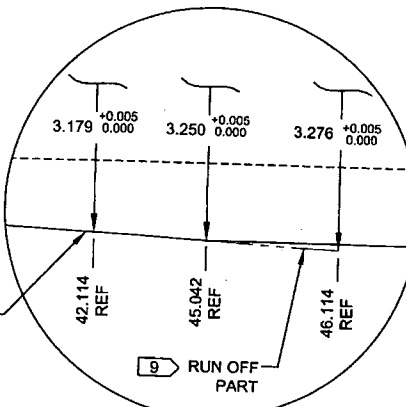


DETAIL D:  
CROSSTUBE CUFF  
SCALE 6X

D212-664-241TRN  
TURNING DETAIL



DETAIL F:  
CUFF TRANSITION  
SCALE 10X



DETAIL E:  
TAPER RUN-OFF  
NOT TO SCALE

w/o 57197

RELEASED  
2009-10-29

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. D
CHECKED	RF	D212-664-241	SHEET 4 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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